

**Work Order ID 54826**

December 22, 2009 1:29:21 PM



Page 1

Item ID: D3785-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/05/10 Start Qty: 8.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CLDate: 09/12/23 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3785

RevD

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3785

Dwg Rev: BProg Rev: D

\*\*\*\*grain direction 45 degree\*\*\*\*

2- Deburr if necessary

HB 10-1-8

8

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-1-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54826

December 22, 2009 1:29:21 PM



Page 2

Item ID: D3785-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/05/10

Start Qty: 8.00



Cust Item ID:

Required Date: 1/15/10

Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ Serial 108

(XS)

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3785

EB 10101/26

(80)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ Serial 27

(XS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54826

December 22, 2009 1:29:26 PM



Page 3

Item ID: D3785-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/05/10 Start Qty: 8.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

1-counter sink holes as per dwg D3785

*EP 10/01/28 (8)*

160

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

*27 8106128*

*(XS)*

170

0.00



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

*BR 10-02-01*

*(8) 8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54826

December 22, 2009 1:29:27 PM



Page 4

Item ID: D3785-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/05/10 Start Qty: 8.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10/02/02

X 8 0

Quality Control

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M112588

Memo

0.00

10/02/03

(XF) 0

Powder Coating

START TIME: 7:00AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 7:30AM

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10-02-3

(8) 4

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 54826

December 22, 2009 1:30:10 PM



Page 5

Item ID: D3785-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/05/10

Start Qty: 8.00



Cust Item ID:

Required Date: 1/15/10

Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Identify as per dwg & Stock Location: 88

0.00



Packaging

Memo

0.00

Packaging

11/10/2/3 (8)

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/03  
ME  
10-2-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 22, 2009 1:29:19 PM

Page 1

Work Order ID: 54826



Parent Item: D3785-3



Parent Item Name: Bracket

Start Date: 1/05/10

Required Date: 1/15/10

Comments: IPP RevD: as per revD (ECN09-716) DD 09.12.03 verified by:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

100

sf

370.3809

2.5112



B 10-1-8

6061-T6 .080 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

370.38087

110630

33.5136

112141

0.86727

113438

336

8

113438

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 54826
<b>Description:</b> BRACKET		<b>Part Number:</b> D3785-3
<b>Inspection Dwg:</b> D3785-3 Rev: D		Page 1 of 1

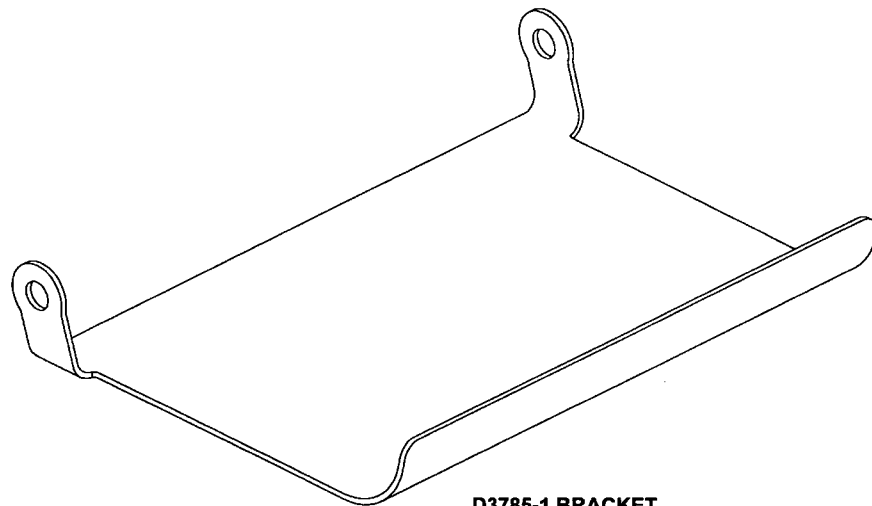
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/- .010	2.002	X			
6.750	+/- .010	6.755	X			
8.500	+/- .010	8.508	X			
9.927	+/- .010	9.933	X			
.203	+/- .010	.203	X			
.405	+/- .010	.405	X			
5.500	+/- .010	5.504	X			
1.500	+/- .010	1.502	X			
3.51	+/- .030	3.514	X			
3.134	+/- .010	3.138	X			
2.259	+/- .010	2.262	X			
1.435	+/- .010	1.433	X			
1.255	+/- .010	1.252	X			
1.427	+/- .010	1.430	X			
Ø .391	+ .006 - .001	.390	X			
Ø .201	+ .005 - .001	.202	X			
.080	+/- .010	.079	X			

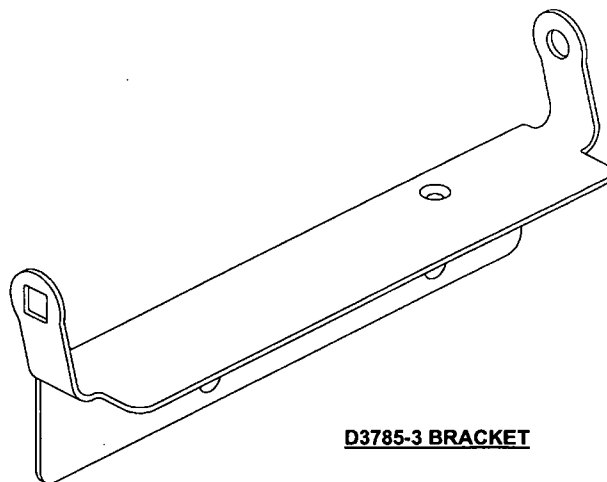
<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-1-8	<b>Date:</b> 10/01/08	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D3785-1 BRACKET**

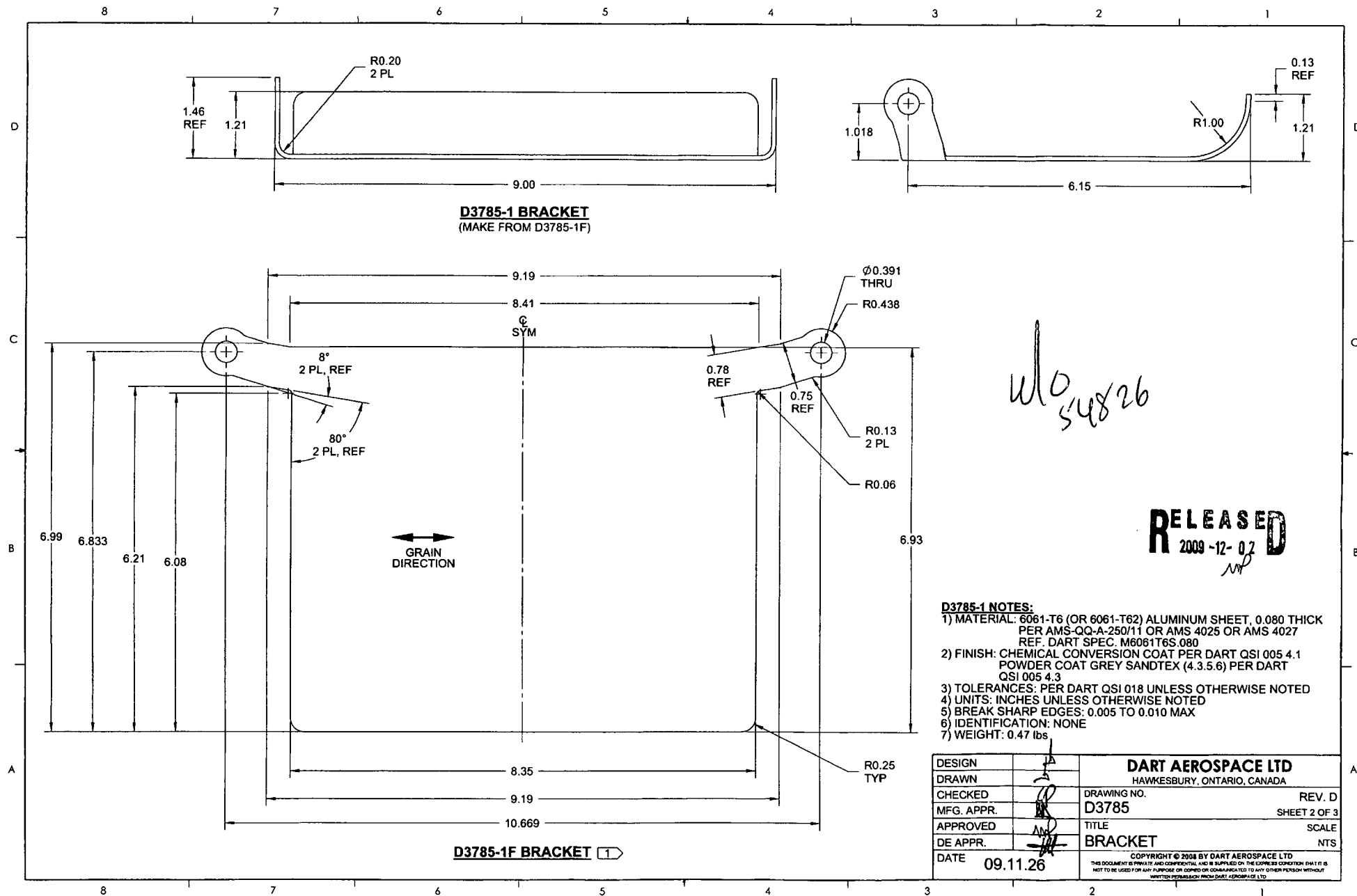
W/O  
54826



**D3785-3 BRACKET**

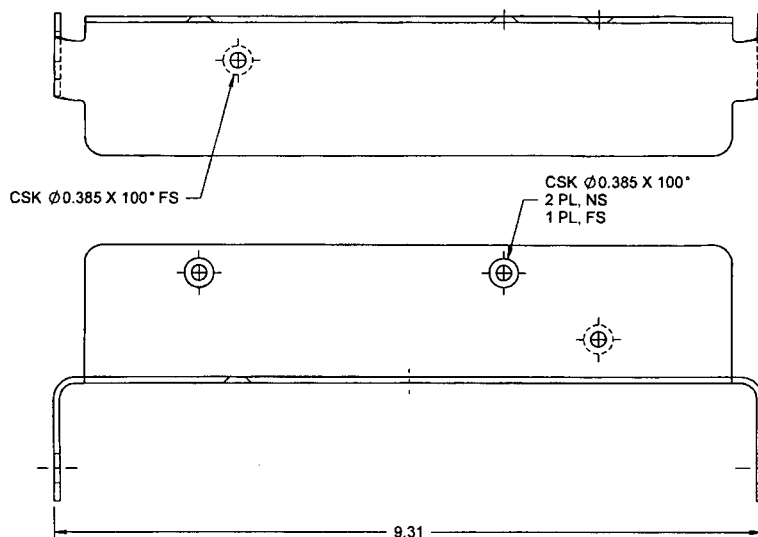
**RELEASED**  
2009-12-02  
MP

D	REVISED D3785-3 AS FOLLOWS: 1.13 WAS 1.05 (ZN C2-3); 1.500 WAS 2.000 (ZN B7-3); 5.500 WAS 6.750 (ZN B5-3). REASON: PROVIDE MORE CLEARANCE FOR CUSHION UPON ASSEMBLY AND HOLE PATTERN NOT MATCHING D3781-1 HOLE PATTERN.	MB	09.11.26
C	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.07
B	REDESIGNED D3785-3; REMOVED PINS D3785-0411-11-51-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.26		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3785</b> REV. D TITLE <b>BRACKET</b> SCALE NTS SHEET 1 OF 3 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

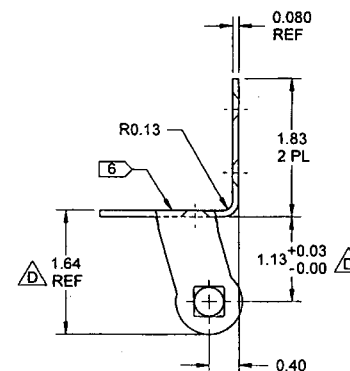


WLO 54826

**RELEASED**  
2009-12-02

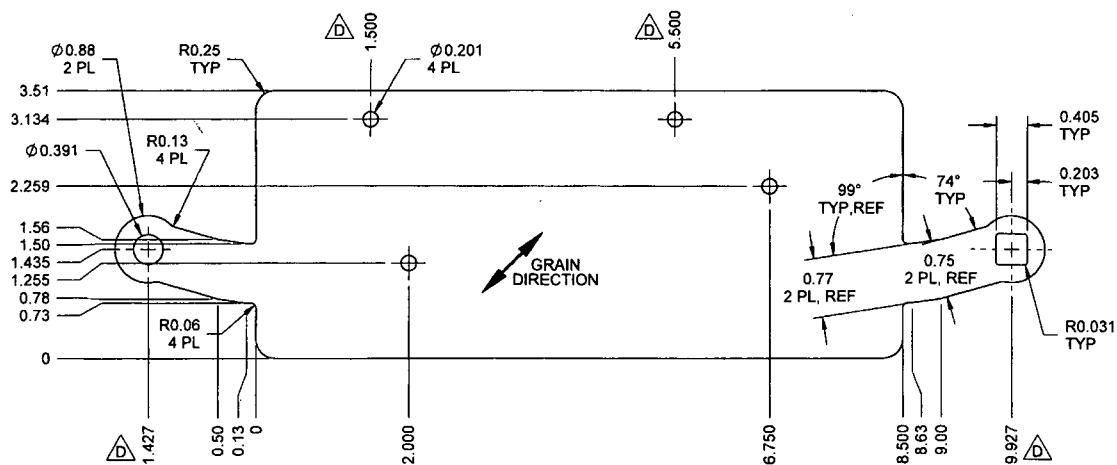


**D3785-3 BRACKET**  
MAKE FROM D3785-3F



*Wb*  
*54826*

**RELEASED**  
2009-12-22



**D3785-3 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDEX (4.3.5.6) PER DART  
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-3" USING FINE  
POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3785	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.11.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	